Work Orden November-21-13		660			Page 1						
Revision ID:	D3589-049 Aft Guide		/	Accept	*N900	040	100)* s	etup Sta	1.7	S1* S2*
Start Date: Required Date: Reference:		Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item :						
		MLJ	Date: 13-11-22 Date:	_		oate:		R	tun Sta Sto)	R1* R2*
Sequence ID/ Work Center ID		peration escription		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revisio	on Nbr			\						
D3589	С										14-02-3
100	W	veld per dwg A/R S.S	. rod Batch: M130854	0.00				1			14-02-3
100 Large Fab			semble and weld as per dwg					2			
110	Q	C9- Inspect visual per	QSI004- Fusion Welds	0.00							DAS 9
110 QC Quality Control		Мето		0.00				_()	14-0	9 <i>9</i> %	9-89
120	Q	C5- Inspect part comp	leteness to step on W/O	0.00							DAS 9
120		Memo		0.00				_2	MC	9-98	9-89

Quality Control

DQA:			Date:										7			
						WORK ORDER NON	-CC	ONFO	AEROSPA	CE						
QA Closed:			Date:			Work Order update only										
Work Orde	3 <i>r•</i>					DISPOSITION	Ì			AGAINST	DE	PARTMENT/PROCESS				
WOIK OIU	-					Rework	1		Skid-tube Crosstube				Water Jet	Engineering	٦	
Part N	J۸					Scrap	1	Machining Small Fab				Pro	d. Eng. Coor.	Quality	1	
	Part No.				Use-as-is	1		noforming	Finishing		4	re/Packaging	Other	1		
NCR I	lo.					Suspected Unapproved			Large Fab	Composite	_		Supplier] []	
									· ·			· · · · · · · · · · · · · · · · · · ·				
Root					Desc	ription of work order update	1	nitial	1	tion		Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	QC Inspecto	<u>r</u>	
Design	Щ														1	
Doc/Data																
Equip/Tooling							ļ							k		
Handling/Pre						•	1									
Material																
Operator	-		1 1													
Offset/Setup																
Process	Ш						1									
Supplier	Н						Ì]		į	
Training	H				ł											
Transport													1			
Unapproved				<u> </u>	ł		<u> </u>	LILT CA	TEGORY			<u> </u>				
Landi						General	FA	<u>OLI CA</u>	TEGORI				· <u> · · · · · · · · · · · · · · · ·</u>			
- Landi		Bending				Bend]Folio/I	Program			Outside Dim	ensions [Pressure/Forced	:	
	\vdash	Centre No	nt Concei	ntric		BOM/Route	\vdash	Grain	106.0		-	Over/Under	-	Set-up		
ļ ļ	\vdash	Cracks	or concei		\vdash	Broken/Damage/Defect		Hardwa	are		\vdash	Part Incorre	<u> </u>	Temperature/Cui	е	
	一	Crimp/Kir	nk/Ripple	/Wave		Burrs	-	4	tion Incomplete/U	Inqualified		Part Lost/M	<u>-</u>	Weld		
	\vdash	Cuffs	yppic	.,		Contamination		4 '	tions Incomplete/	•	\vdash	Part Moved	_	Wrong Stock Pull	ed	
	\vdash	Crushing				Countersink		4	gned/off center		Г	Positioned \	limit to the second sec			
	H	Heat Trea			-	Cut Too Short		Mislab	-			Power Loss/		Other		
		Inspectio		Tube		Drawing		Misrea				_	- L			
		Marks/Ch	•			Drill Holes		Off-set								
		Turning S		!		Finish		Out of	Calibration							
1		Wave/Twist in Tube				Fit/Function		Out of	Sequence							

Work Orde November-21-13				*109				Page 2				
Item ID: Revision ID: Item Name:	D3589-049 Aft Guide		,	Accept	*N900	040	100)* s	etup Star Stoj	1 /	S1* S2*	
Start Date: Required Date: Reference:	11/21/13 11/21/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item I Customer:	D:						
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):	Date: Date:				un Star Stoj	. "I V I	R1* R2*	
Sequence ID/ Work Center II 130 *120* Packaging Packaging	D	Operation Description Identify as per dwg & Sto	ock Location: <u>STCS</u>	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty DAS 28 / 9-89	Reject Number	Insp. Stamp	

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

140

*14**0***

Quality Control

ML5 14-02-28

DQA:			Date:													
						WORK ORDER NON-	AEROSPAC	E								
QA Closed:			Date:													
Work Order:						DISPOSITION				AGAINST I	DEP	PARTMENT/PROCESS				
Part No.						Rework Scrap		Skid-tube Crosstul Machining Small Fa					Water Jet d. Eng. Coor.	Engineering Quality		
NCR I	NCR No.					Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite		Rec/Stor	e/Packaging Supplier	Other		
Root	ot Des			Desci	ription of work order update		nitial	Act	tion		Sign &					
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription		Date	Verification	QC Inspector		
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport													·			
Unapproved	<u> </u>			<u> </u>	L			III T CA	I TEGORY						-	
Landi	na (·			General	10	<u>OLI CA</u>	TEGOR!							
Landi	ng (Bending Centre No	ot Concer	ntric	E	Bend BOM/Route	E	Folio/F Grain	Program	[-	Outside Dim Over/Under		Pressure/Forced Set-up		
		Cracks				Broken/Damage/Defect		Hardwa	are			Part Incorre	:i	Temperature/Cure	•	
	L	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/U	nqualified	∐ ^F	Part Lost/Mi	ssing	Weld		
		Cuffs				Contamination		Instruc	tions Incomplete/	Unclear	F	Part Moved		Wrong Stock Pulle	d	
		Crushing				Countersink		-	gned/off center			Positioned V		_		
l	L	Heat Trea			L	Cut Too Short		Mislab		l		Power Loss/	Surge	Other		
1	L	Inspectio	n Strip in	Tube		Drawing		Misrea			_					
		Marks/C	atter			Drill Holes		Off-set			_					
	L	Turning S	equence			Finish		Out of	Calibration		_					
		Wave/Twist in Tube				Fit/Function		Out of	Sequence							

Page 1

Work Order ID:

109560

Parent Item:

D3589-049

Parent Item Name:

Aft Guide

Start Date: 11/21/13

Required Date: 11/21/13

Start Qty: 2.00

Required Qty: 2.00

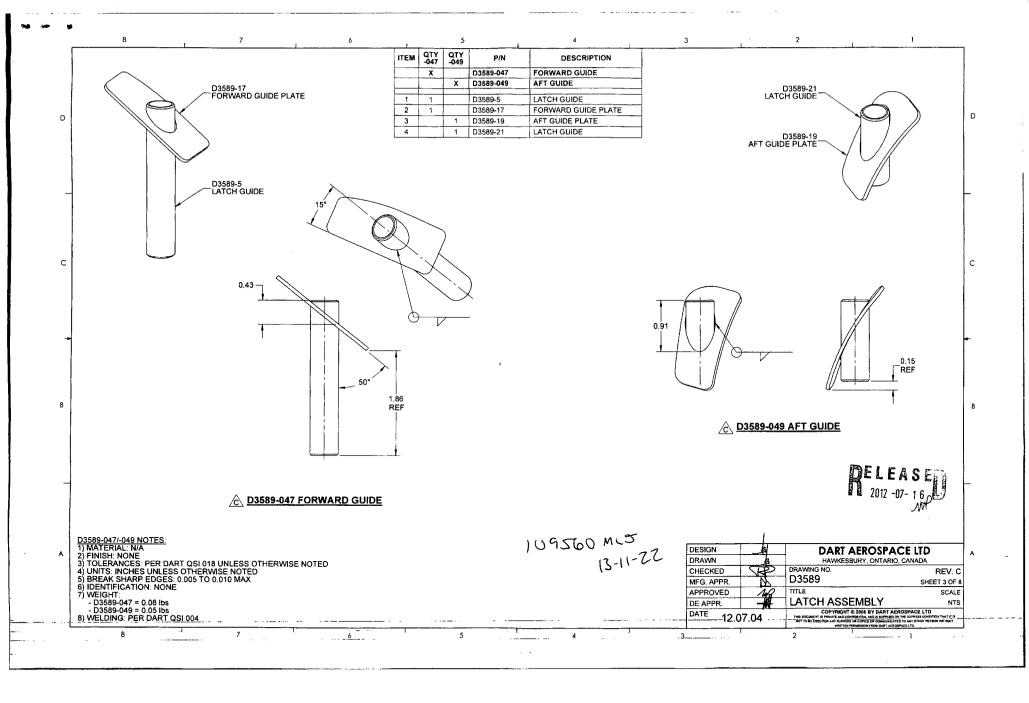
Comments:

IPP Rev:A 08-05-30 new issue DD verified by:ec

IPP REV:B 12.07.23 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3589-19		Manufactured	No			100	Each	16.0000	1	2			14-07-2
Aft Guide Plate									(10/2) 				1100
				Location		Loc Oty	L	oc Code					130
				WA002		16			/^				1
				[1084	69)	16			_/ə	رون			
03589-21		Manufactured	No			100	Each	25.0000	1	<u>ئ</u>			111 60
Latch Guide											· · · · · · · · · · · · · · · · · · ·		14-01-
				Location		Loc Qty	<u>L</u>	oc Code					On-
				ST056		13							XI
				1079	17	13							/
				WA002 47	122	12			_ 📆				
				1076	23	12				* *			

DQA:	····		Date:			WORK ORDER NON-		ſ						
QA Closed:			Date:			WORK ORDER HOR) (11 O	WINITEL / C		Nork Order	update only	T AEROSPAC	E
Work Orde	r:					DISPOSITION				AGAINST [EPARTMEN	T/PROCESS		
Part No						Rework Scrap Use-as-is Suspected Unapproved		Thern	Skid-tube Cross Machining Sma Thermoforming Fini Large Fab Comp		-	Water Jet rod. Eng. Coor. ore/Packaging Supplier	Engineering Quality Other	
Root	Des				Desc	ription of work order update		nitial	Ac	tion	Sign &			
Cause		Date	Step Qty			or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector	
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved														
							FA	ULT CA	regory					
Landi	nding Gear Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter					General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes		Grain Hardwa Inspect Instruct Misalia Mislaba Misrea Off-set	ion Incomplete/U tions Incomplete, gned/off center eled d	/Unclear	_	Missing ed d Wrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled	
		Turning Sequence Wave/Twist in Tube				Finish Fit/Function		-	Calibration Sequence					



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